

Date: Tuesday, 07/04/2009 10:17:04 AM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: STEP STRUT		
Job Number	: 46945			Part Number	: D2017127		
Estimate Number	: 11940			Drawing Number	: D2017 REV E/F		
P.O. Number	:			Project Number	: N/A		
This Issue	: 07/04/2009	S.O. No.	:	Drawing Revision	: E/F <i>Mo9/04/28</i>		
Prsh Rev.	: NC			Material	:		
First Issue	: //	Type	: SMALL /MED FAB	Due Date	: 22/04/2009		
Previous Run	: 43577			Qty:	4 Um: Each		
Written By	:						
Checked & Approved By	: <i>JUL 09.04.07</i>						
Comment	: Est F 02.06.19 Update processes (Ref. ECN 435) KJ						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0750W049	304 RD Tube .750 x .049W
		 Comment: Qty.: 1.8025 f(s)/Unit Total : 7.2101 f(s) Punch tube type 304-2B, $\frac{3}{4}$ " Ø X .049" wall to length per Dwg. D2017 & spec control D2638 Batch No. <i>M 111331</i> <i>SB 09/04/27</i> (4)
2.0	QC5	INSPECT WORK TO CURRENT STEP
3.0	POWDER COATING	 Comment: INSPECT WORK TO CURRENT STEP <i>SB 09/04/28 (X)</i> (4)
		 Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3 START TIME: <i>15:34:00</i> OVEN TEMPERATURE: <i>400°</i> FINISH TIME: <i>16:10:00</i> <i>m109996</i> <i>09/04/28</i> (4)
4.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		 Comment: INSPECT POWDER COAT <i>Fd 09/04/29</i> (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STEP STRUT

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST25E

ST25E

8809/04/2009

6.0 QC21

FINAL INSPECTION/W/O RELEASE



09/04/2009
JH

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-04-29

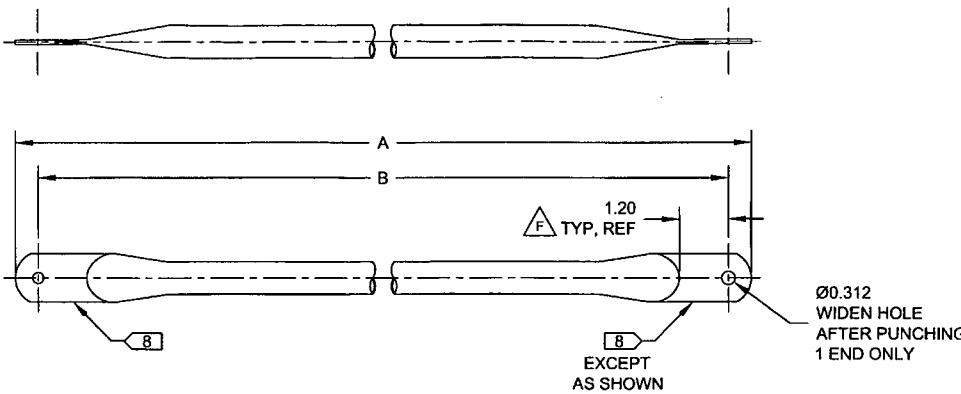
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D2017-XXX STEP STRUT

PART NUMBER	A	B
D2017-101	17.73	16.93
D2017-103	18.74	17.94
D2017-113	20.50	19.70

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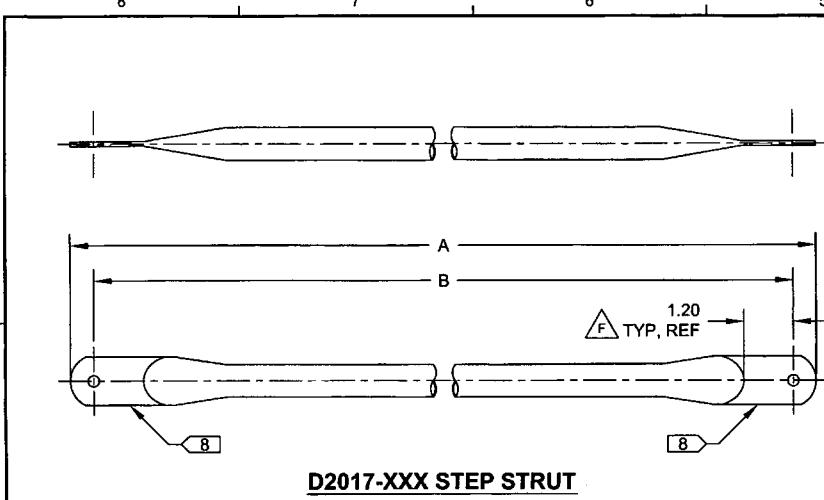
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE, Ø0.750 x 0.049 WALL
REF. DART SPEC M304TR0.750W.049
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2017-XXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: N/A
- 8) PUNCH ENDS PER SPEC CONTROL DRAWING D2638.

RELEASED
09/04/16 MW

F	DRAWING TRANSFERRED TO "B" FORMAT AND TO CURRENT STANDARDS. REDRAWN FOR CLARITY 1.20 REF DIM ADDED. SEE PAR 09-002 FOR DETAILS.	AJS	09.03.06
E	ENDS PUNCHED PER SPEC CTRL; -119 CHANGE (TSR A897) ADD FINISH (INCORPORATE E1)	CP	02.03.22
D	ADDED PARTS	BW	96.03.28
C	ADDED PARTS	BW	95.01.26
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2017	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STEP STRUTS	NTS
DATE	09.03.06	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT WAS SUPPLIED. IT IS THE PROPERTY OF DART AEROSPACE LTD.	

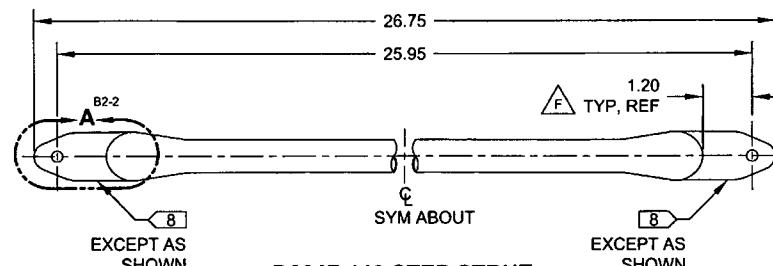
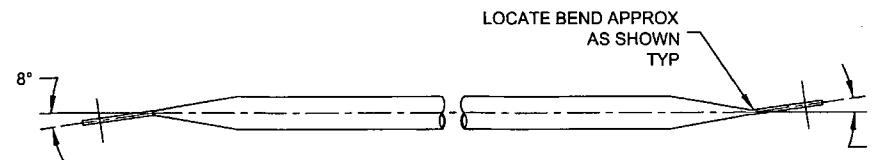
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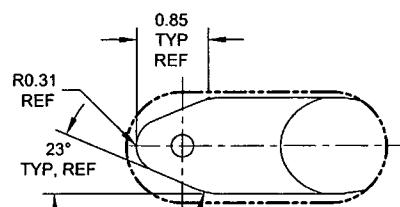
D2017-XXX STEP STRUT

PART NUMBER	A	B
D2017-105	14.95	14.15
D2017-107	15.61	14.81
D2017-109	13.93	13.13
D2017-111	15.30	14.50
D2017-115	12.42	11.62
D2017-117	13.86	13.06
D2017-121	12.30	11.50
D2017-123	12.92	12.12
D2017-125	19.55	18.75
D2017-127	20.30	19.50
D2017-129	31.43	30.63
D2017-131	19.68	18.88
D2017-201	21.31	20.51
D2017-203	16.39	15.59
D2017-205	16.53	15.73
D2017-207	13.85	13.05
D2017-209	15.64	15.33
D2017-211	15.67	14.87
D2017-213	15.82	15.02
D2017-215	16.47	15.67
D2017-217	16.70	15.90
D2017-219	13.65	12.85
D2017-221	13.58	12.78
D2017-223	12.95	12.15
D2017-225	13.99	13.19
D2017-227	30.67	29.87
D2017-133	30.66	29.86

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D2017-119 STEP STRUT
(SHOWN PRIOR TO BENDING)



REF **DETAIL A** D4-2
TRIM AFTER PUNCHING PER DT8360
SCALE 2X

RELEASED
09/04/16 MAF

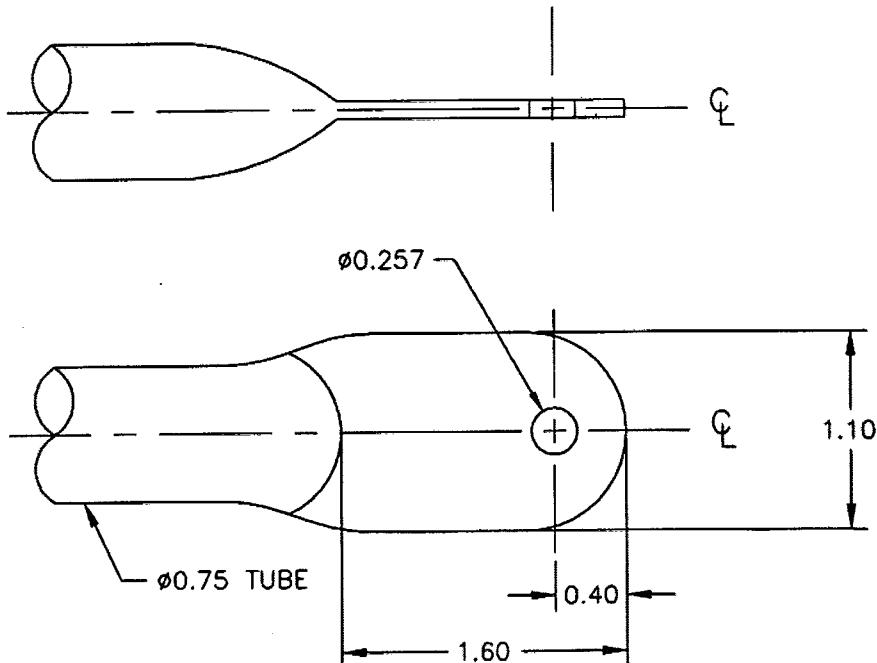
DESIGN	BW	DART AEROSPACE LTD	
DRAWN	A/S	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[initials]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[initials]</i>	D2017	SHEET 2 OF 2
APPROVED	<i>[initials]</i>	TITLE	SCALE
DE APPR.	<i>[initials]</i>	STEP STRUTS	NTS
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DART

DESIGN CHECKED DATE	DRAWN BY APPROVED	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. TITLE	REV. A SHEET 1 OF 1 SCALE 1:1
<i>KE</i> <i>NO</i>	<i>KE</i>	D2638 PUNCH DT8117 SPEC CONTROL	
98.04.28	A 98.04.28 NEW ISSUE		

RELEASED
98/05/05 KE

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8117



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